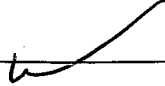
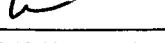


Date: Friday, 21/07/2006 12:04:53 PM  
User: Linda Lacelle

# Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : SADDLE SPACER
<b>Job Number</b> : 27969	
<b>Estimate Number</b> : 10376	
<b>P.O. Number</b> : N/A	<b>Part Number</b> : D2885
<b>This Issue</b> : 21/07/2006 <b>S.O. No.</b> : N/A	<b>Drawing Number</b> : D2885 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : N/A <b>Type</b> : MACHINED PARTS	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 28026	<b>Material</b> : N/A
<b>Written By</b> : 	<b>Due Date</b> : 07/08/2006 <b>Qty:</b> 40 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : 	
<b>Comment</b> : Est A 99.10.12 New Issue EC Est Rev:B Now 6060-T6 06-06-23 JLM Est Rev:C waterjet 06-07-23 ec	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.0270 sf(s)/Unit Total : 1.0794 sf(s)  
Material: 6061-T6 (QQ-A-250/8) 0.080" Thick  
Batch M101178

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Prog. B  
Drw. B



**Comment:** FLOW WATER JET

SAD 06:08:08

40

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

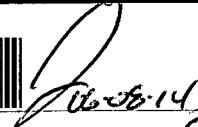
SAD 06:08:08

40

4.0	QC8	SECOND CHECK
-----	-----	--------------



**Comment:** SECOND CHECK

  
06-08-14 (39) P-10


5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
Acid etch and Alodine as per QSI 005 4.1

SC 06/08/15  
DL

40

5.0 deburr parts - ml 06/08/14  


(39)

Date: Friday, 21/07/2006 12:04:53 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 27969

Part Number: D2885

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06.08.21*

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST393*

*06/08/22*

*89*

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06.08.23*

Job Completion



*06/08/22*

*PTD -7*

Date: Tuesday, 7/18/2006 3:00:50 PM  
 User: Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SADDLE SPACER
<b>Job Number</b> :	27969		
<b>Estimate Number</b> :	10376		
<b>P.O. Number</b> :		<b>Part Number</b> :	D2885
<b>This Issue</b> :	7/18/2006	<b>S.O. No.</b> :	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D2885 REV B
<b>First Issue</b> :	/ /	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	23926	<b>Drawing Revision</b> :	B
	<b>Type</b> :	<b>Material</b> :	
	MACHINED PARTS	<b>Due Date</b> :	8/7/2006
<b>Written By</b> :		<b>Qty:</b>	40
<b>Checked &amp; Approved By</b> :		<b>Um:</b>	Each
<b>Comment</b> :	Est A 99.10.12 New Issue EC Est Rev:B Now 6060-T6 06-06-23 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	M6061T6S080	6061-T6 .080 Sheet
-----	-------------	--------------------



**Comment:** Qty.: 0.0270 sf(s)/Unit Total : 1.0794 sf(s)  
 Material: 6061-T6 (QQ-A-250/8) 0.080" Thick  
 Batch \_\_\_\_\_

2.0	SHEAR	SHEAR
-----	-------	-------



**Comment:** SHEAR  
 Blank: 7.90" x 3.50" (+0.030" - 0.000")  
 1 blank makes 4 parts

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



**Comment:** HAAS CNC VERTICAL MACHINING #1  
 1-Machine per folio D2885  
 2-Tumble  
 3-Deburr any rough edges after tumbling

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--




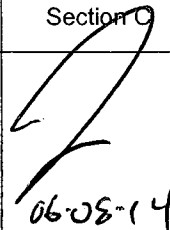
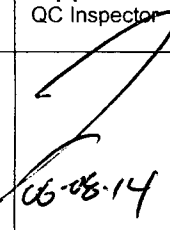
**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE


5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



**Comment:** HAND FINISHING RESOURCE #1  
 Acid etch and Alodine as per QSI 005 4.1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06-08-14	4	1 Part scrap. Water Jet blow-out on hole.		destroy.	J.G 06/08/14	 06-08-14	N/A.	 06-08-14

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA:  Date: 06-08-23

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Tuesday, 7/18/2006 3:00:50 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 27969

Part Number: D2885

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

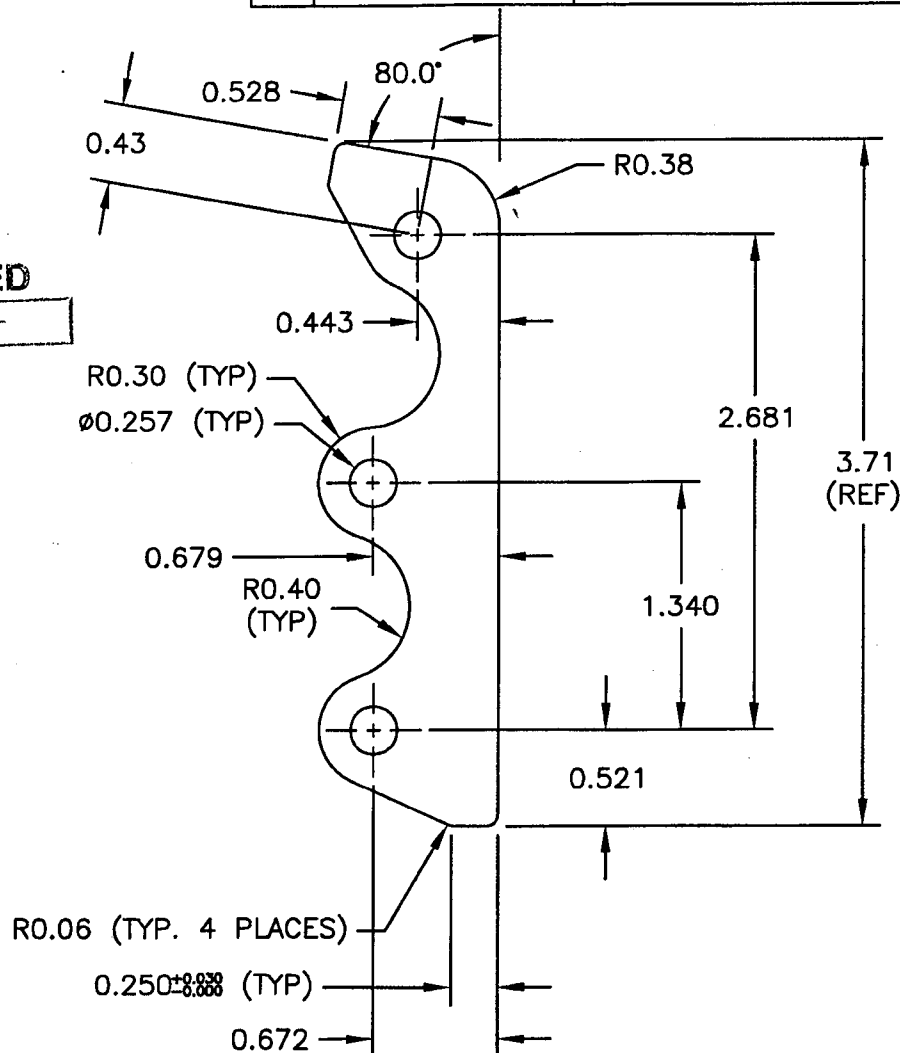
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_



DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2885	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.04.01	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

RELEASED

*cl. d. v. [Signature]*



**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027)  
0.080" THICK (REF DART SPEC M6061T6S.080)  
OR  
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016)  
0.080" THICK (REF DART SPEC M5052H32S.080)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 27969

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DART AEROSPACE LTD		Work Order: 27969
Description:		Part Number: D2885
Inspection Dwg:	Rev: B	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.43	$\pm 0.030$	0.429	✓		Vern	
0.443	$\pm 0.010$	0.448	✓		Vern	
Ø 0.257	$\pm 0.006$	Ø 0.260	✓		Vern	
R0.30	$\pm 0.030$	R0.30	✓		R-G	
0.679	$\pm 0.010$	0.678	✓		Vern	
R0.40	$\pm 0.030$	R0.40	✓		R-G	
0.250	$\pm 0.010$	0.248	✓		Vern	
0.672	$\pm 0.010$	0.675	✓		Vern	
0.521	$\pm 0.010$	0.517	✓		Vertical Vern	
1.340	$\pm 0.010$	1.346	✓		Vertical Vern	
2.681	$\pm 0.010$	2.687	✓		Vertical Vern	
3.71	$\pm 0.030$	3.69	✓		Vern	
R0.38	$\pm 0.030$	R0.38	✓		R-G	
0.528	$\pm 0.010$	0.526	✓		Vertical Vern	
0.080	$\pm 0.010$	0.80	✓		Vern	

Measured by: SAD	Audited by: [Signature]	Prototype Approval: N/A
Date: 06.08.08	Date: 06.08.14	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	